

Date: Thursday, 13/11/2008 1:06:24 PM
 User: Julie Dawson

Process Sheet

| | | | | |
|------------------------------------|-------------------------------------|---------------------------|-----------------------|-------------------------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | BATTERY LOCK ASSEMBLY | |
| Job Number : | 43420 | Part Number : | D3393041 | |
| Estimate Number : | 10900 | Drawing Number : | D3393 REV A / D3369-5 | |
| P.O. Number : | | Project Number : | N/A | |
| This Issue : | 13/11/2008 | S.O. No. : | | |
| Prsht Rev. : | NC | Drawing Revision : | A | |
| First Issue : | 1/1 | Material : | N/A | |
| Previous Run : | 40643 | Due Date : | 10/12/2008 | Qty: 4 Um: Each |
| Written By : | | | | |
| Checked & Approved By : | JLD 08.11.14 | | | |
| Comment : | Est Rev:A | New Issue | 06-11-22 | JLM |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|--------|-------|
| 1.0 | D27287 | Label |
|-----|--------|-------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2728-7

Decal

22554

comp? want take it.

SS 09/01/08 (X)

| | | |
|-----|--------|----------|
| 2.0 | D33731 | Cam Lock |
|-----|--------|----------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3373-1

Cam Lock

44105

CHECK WITH PRODUCTION IF KEYED ALIKE OR UNALIKE

SS 09/01/08 (X)

| | | |
|-----|-------|---------------------|
| 3.0 | 516WC | SS Flat Washer 5/16 |
|-----|-------|---------------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 5/16WC

SS Flat Washer

M109326

SS 09/01/08 (X)

| | | |
|-----|--------|---------------------|
| 4.0 | D33931 | Battery Lock Casing |
|-----|--------|---------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3393-1

Battery Lock Casing

43123

SS 09/01/08 (X)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 13/11/2008 1:06:25 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BATTERY LOCK ASSEMBLY

Job Number: 43420

Part Number: D3393041

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 D33933 Cam Lock Shaft



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3393-3

Cam Lock Shaft

44108

88 09/01/08 (x4)

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Open D3373-1 lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest.

2-Using the flat cam, fabricate D3369-5 as per Dwg D3369 Identify as D3369-5

3-Assemble D3393-041 as per Dwg D3393. Insert lock body and fasten with lock body nut, apply locktite, then insert lock barrel. Insert D3369-5 fabricated washer and 5/16" SS washer. Thread D3393-3 shaft into lock, then install decal.

A/RN/A262 Locktite

1110005

4-Identify as D3393-041 and attach keys. Ensure that assembly locks and unlocks smoothly. Record the Key

Key Numbers

1-C420A

5-_____

2-C420A

6-_____

3-C420A

7-_____

4-C420A

8-_____

EB 09/01/19 (4)

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Tack Weld lock shaft to flat cam of a Max 1/8" Long

Qty Part Number Description Batch

A/R N/A

SS Rod

M107051

12 9-1-21 x4

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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Drawing Name: BATTERY LOCK ASSEMBLY

Job Number: 43420

Part Number: D3393041

Job Number:



Seq. #: Machine Or Operation: Description :

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-01-21 (4)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Apply Crazy Glue to cap and press into Body

9567K21 Batch: 17109946

EP 09/01/21 (4)

10.0

9567K21

Polyethelene Cap



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Polyethelene Cap

11/9/02

EP 09/01/21

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

502/01/21 (4)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 486

88 09/01/22 (4)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/26

Job Completion



MF 09-01-22

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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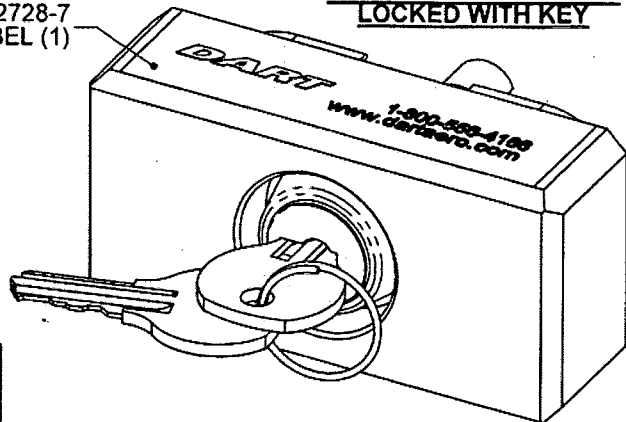
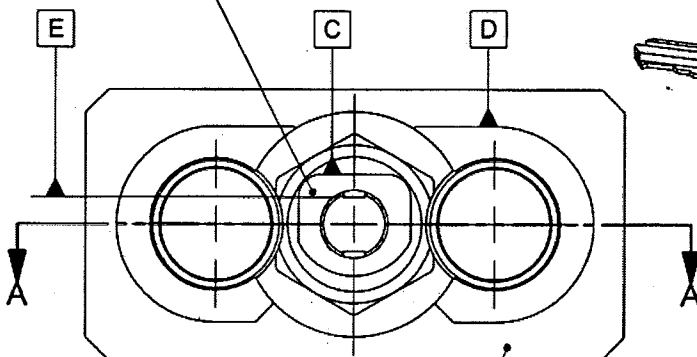
NOTE: Date & initial all entries

DART

| | | | |
|-------------------------|-----------------|--|------------------------|
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| CHECKED RT | APPROVED AJS | DRAWING NO. D3393 | REV. A SHEET 1 OF 3 |
| DATE 05.02.08 | | TITLE BATTERY LOCK | SCALE 1:1 |
| A | 05.02.08 | NEW ISSUE | |

RELEASED

05/03/09

D2728-7
LABEL (1)**BATTERY LOCK SHOWN
LOCKED WITH KEY**POSITION FACE **C** OF D3369-5
PARALLEL TO FACES **D** AND **E**
AS SHOWND3373-1
CAM LOCK
ASSEMBLY (1)D3393-1
CASING (1)Ø5/16" WC S/S
WASHER (2)

D3369-5 SPACER (1)

PRESS FIT POLYETHYLENE CAP (2) $\frac{2}{2}$
AND APPLY KRAZY GLUE0.09 $\begin{smallmatrix} +0.03 \\ -0.01 \end{smallmatrix}$ (2 PLACES)D3393-3 CAM
LOCK SHAFT (1)TACK WELD
D3393-3 TO D3369-5**SECTION A-A****D3393-041 BATTERY LOCK ASSEMBLY****NOTES:**

- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 9567K21

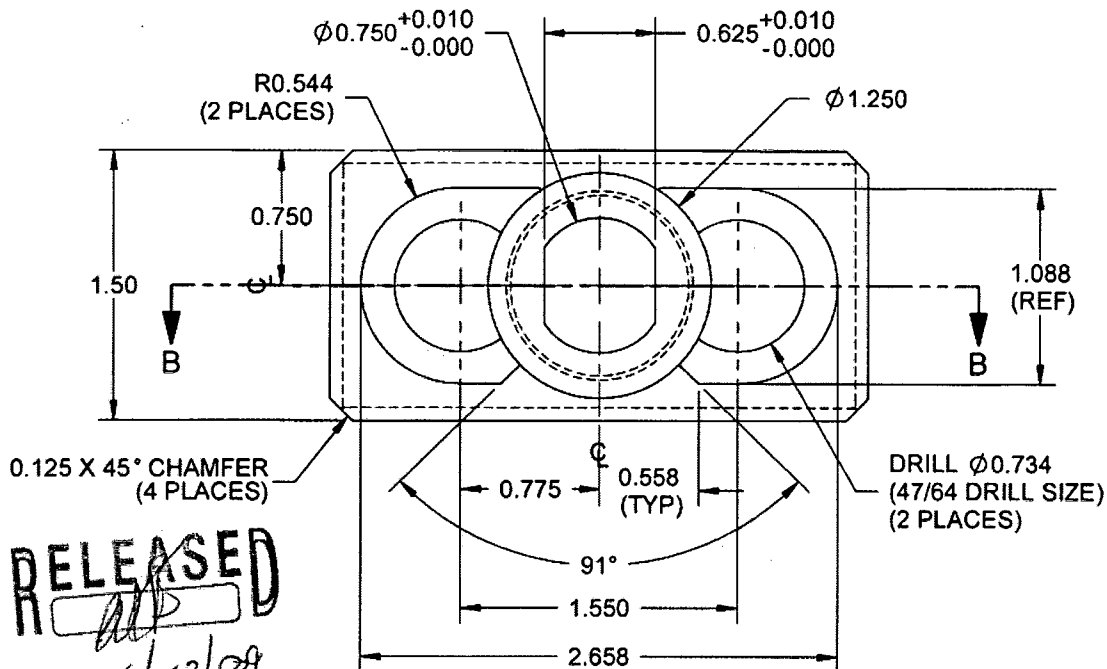
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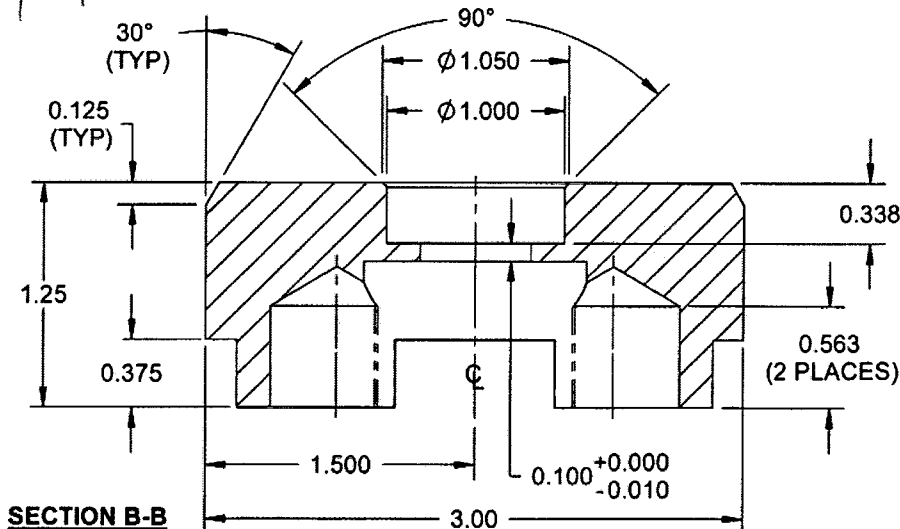
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| CHECKED 14 | APPROVED <i>[Signature]</i> | DRAWING NO. D3393 | REV. A SHEET 2 OF 3 |
| DATE 05.02.09 | | TITLE BATTERY LOCK | SCALE 1:1 |



RELEASED
[Signature]
05/03/09



SECTION B-B

D3393-1 CASING

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

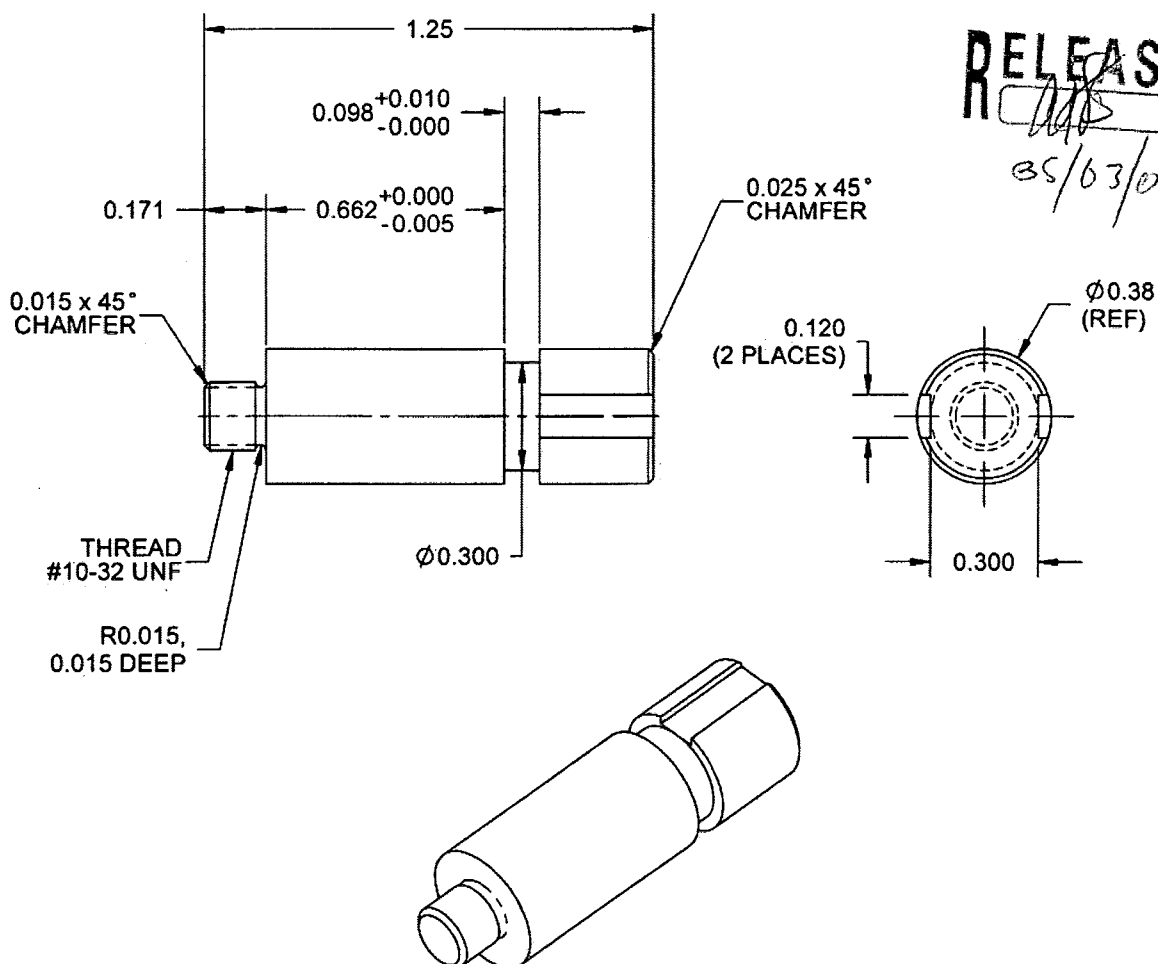
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| DATE 05.02.09 | | TITLE BATTERY LOCK | SCALE 2:1 |



D3393-3 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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